

Work Order ID 71104

Wednesday, June 22, 2011 2:38:55 PM



Page 1

Item ID: D2065

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 6/22/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2065

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Punch 1/2" OD x .049" Wall 304/316 SS as per Dwg D2065 (per D2727) using DT8012.
Note: 1 end only
2-Cut to length as per Dwg D2065
3-Form as per Dwg D2065 and template DT8251
4-Drill 0.188" Dia holes as per Dwg D2065 using drill jig DT8779 and template

Handwritten signature and date: 6/27/11 with circled 10

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Handwritten signature and date: 6/27/11

Handwritten circled 10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:00
OVEN TEMPERATURE: 3200F
FINISH TIME: 2:30

10x0 M/L 6/27

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 0 40 6/28

140

Identify as per dwg & Stock Location: 51229 0.00



Packaging

Memo

0.00

Packaging

CL 6/28 (10)

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Page 3

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Item Name: Arm

Start Date: 6/22/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28 JJ

MF
11-06-28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 22, 2011 2:38:52 PM

Page 1

Work Order ID: 71104

Parent Item: D2065

Parent Item Name: Arm



Start Date: 6/22/2011

Required Date: 6/30/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: E02.04.15 Added Dwg Rev.B1 NG
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.049

Purchased

No

120

f

278.2132

1.7

17.89474



304 RD Tube .500 x .049W

Location

Loc Qty

Loc Code

MAT017

278.213166

111814

2.23

115010

175.983166

117598

100

Handwritten signature/initials

17.89474

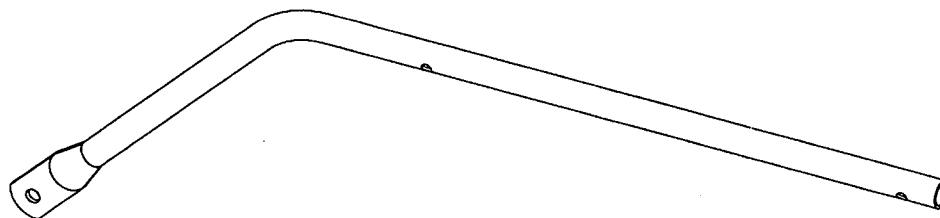
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D2065 ARM

71104

RELEASED
08-07-13

C	REDRAWN IN SOLIDWORKS; INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A6-2); ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2); REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE		PH	08.06.13
B	RE-DESIGN		BW	96.02.06
A	NEW ISSUE		BW	92.03.12
REV.	DESCRIPTION		BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2065 REV. C SHEET 1 OF 2 TITLE ARM SCALE NTS COPYRIGHT © 1992 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	PH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.06.13			

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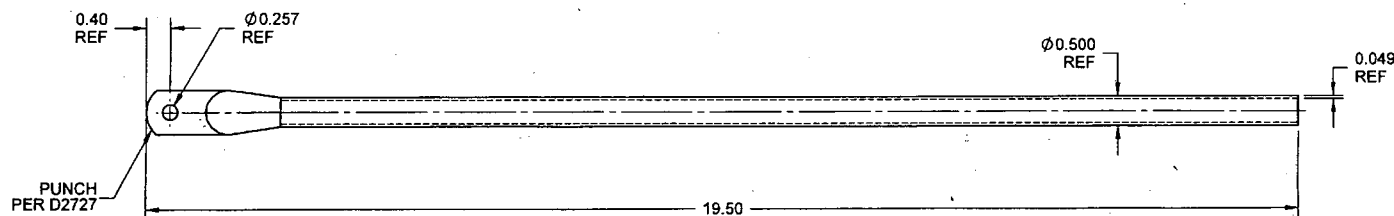
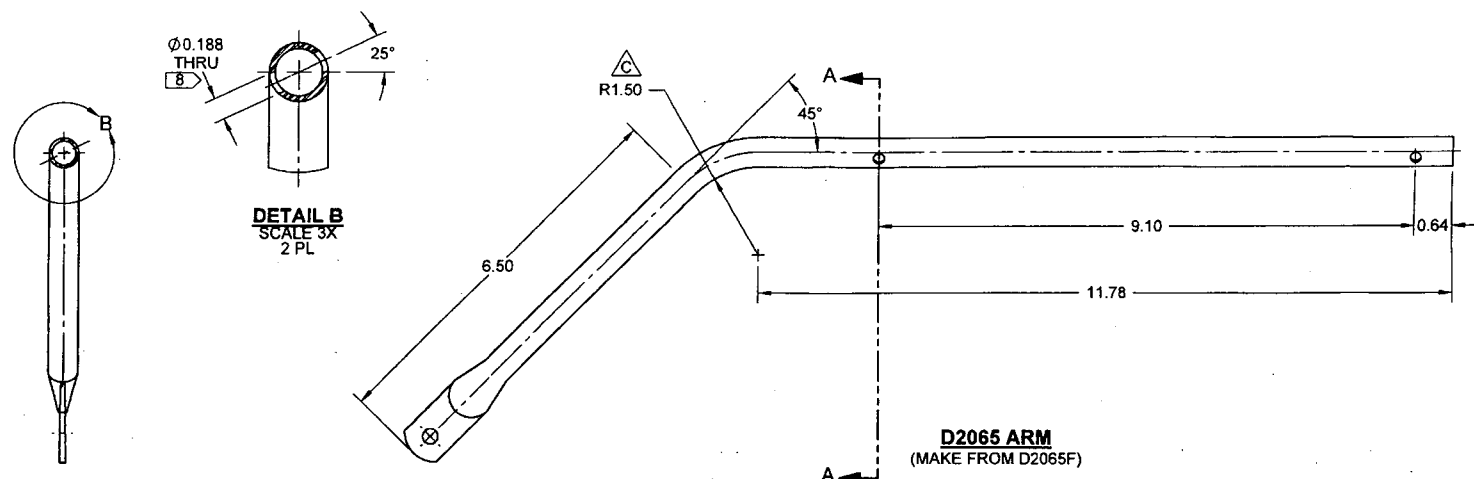
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8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: D2065F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs
- 8) DRILL $\phi 0.188$ AFTER BENDING

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	IS	DRAWING NO. D2065	REV. C
MFG. APPR.	IS	TITLE ARM	SHEET 2 OF 2
APPROVED	IS	SCALE	NTS
DE APPR.	IS	COPYRIGHT © 1992 BY DART AEROSPACE LTD	
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08.07.2013

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8 7 6 5 4 3 2 1

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